Tuesday, February 01, 2011 7:07:51 AM

Item ID:

D3391-023

Revision ID:

Item Name: Mid Tube Assembly

**Start Date:** 

2/1/2011

Start Qty: 1.00 Req'd Qty: 1.00



Accept



Setup Start

Stop



Page 1

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 2/1/2011

**Process Plan:** 

QC:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

**Draw Nbr** 

Revision Nbr

D3391

Rev H

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" exept for fwd saddle hole of detail

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

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W/O:			WC	RK ORDER CHANG	ES				
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Tuesday, February 01, 2011 7:07:51 AM

Item ID:

D3391-023

Accept

Setup Start

Stop



**Revision ID:** Item Name:

Mid Tube Assembly

**Start Date:** 

Required Date: 2/1/2011

2/1/2011

QC:

Start Oty: 1.00

Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

Operation **Description** 

Set Up/ Run Hours Tool ID

Tool # Plan Code

11-2-1

Accept Qty

Reject Qty

Reject Insp. Number Stamp

11-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*

12-Locate D3391-021-in D3391-023 at 9.00" (see view z-z)

Date:

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previusly drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previusly tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previusly drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

11-2-1

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Tuesday, February 01, 2011 7:07:51 AM

Item ID:

D3391-023

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Mid Tube Assembly

Required Date: 2/1/2011

2/1/2011

Start Qty: 1.00

**Req'd Qty:** 1.00

**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

Approvals:

**Process Plan:** 

Date:

**Tooling:** 

Date: \_\_\_\_

Start Run



QC:

Date: \_\_\_\_

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

110

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

120

Hand Finishing

Memo

Memo

Memo

0.00

1 0 BE11/02/01

130

Quality Control

QC3- Inspect Part Finish

0.00

0.00

11-2-1

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Tuesday,	February	ÒΙ,	2011	7:07:51	AM
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Item ID:

D3391-023

**Revision ID:** Item Name:

Mid Tube Assembly

**★Start Date:** 

2/1/2011

Start Qty: 1.00

Required Date: 2/1/2011

**Req'd Qty:** 1.00



Accept



Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

**Process Plan:** 

Date: Date:\_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Tool # Plan

Code

Run

Accept

Qty

Start



Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

140

Skidtubes Skidtubes

Skidtubes

Memo

Operation

Description

0.00

0.00

1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

A/R Sikaflex exp: 11-9-30

batch#: M116040

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Weld crossbolt spacer as per dwg D3391 & QSI 004

2-grind weld flush

W/O:		WORK ORDER CH	ANGES					
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Tuesday, February 01, 2011 7:07:51 AM



Page 5

Item ID:

D3391-023

Accept

Setup Start

Stop

Revision ID:

Item Name:

Required Date: 2/1/2011

Mid Tube Assembly

**Start Date:** 

2/1/2011

Start Otv: 1.00

Req'd Oty: 1.00



Date:

**Cust Item ID: Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Tool ID

Date:

Tool # Plan

Code

Reject

Oty

Start

Sequence ID/ **Work Center ID** 

170

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Un/ Run Hours

Run

Stop

Reject

Number Stamp

Insp.

180

OC

Quality Control

OC5- Inspect part completeness to step on W/O

à ulvelor

Accept

Qty

185

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

1 Bl 11-02-2

W/O:			WC	RK ORDER CHANG	ES	_		. [	,	
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Tuesday, February 01, 2011 7:07:51 AM

Item ID:

D3391-023

**Revision ID:** 

Item Name:

Mid Tube Assembly

**Start Date:** 

2/1/2011



Date:

Accept

Setup Start

Stop



Required Date: 2/1/2011

Start Qty: 1.00 **Req'd Qty:** 1.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Start Run

Reject

Qty

Accept

Qty

Stop



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

190

Powdercoat

Powder Coating

Operation **Description** 

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/

**Run Hours** 

0.00

0.00

200

QC Quality Control

QC3- Inspect Part Finish

Memo

0.00

11/02/02

0.00

W/O:		WORK ORDER CHA	NGES				
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Tuesday, February 01, 2011 7:07:51 AM



Page 7

Item ID:

D3391-023

Accept

Setup Start



**Revision ID:** 

Item Name:

Mid Tube Assembly

Start Date:

2/1/2011

Start Qty: 1.00

Required Date: 2/1/2011

Req'd Qty: 1.00



Cust Item ID: **Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:\_\_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop



Sequence ID/ Work Center ID

210



Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using Tpins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)	)				
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Tuesday, February 01, 2011 7:07:51 AM



Item	ID:

D3391-023

**Revision ID:** Item Name:

Mid Tube Assembly

**Start Date:** 

2/1/2011

Start Qty: 1.00

Required Date: 2/1/2011

Req'd Qty: 1.00



Date: SPC (Y/N):

Accept



**Cust Item ID:** 

**Customer:** 

Tool ID

Run

Setup Start





Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Date:

Tool # Plan

Code

Start

Stop



Number Stamp

Insp.

Sequence ID/ Work Center ID

230

HandFinish

Hand Finishing

Operation Description

HandFinishing

Memo

Install Inserts as per Dwg

Set Up/ Run Hours

11/02/02

Otv

Reject

Reject

240

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Accept

Qty

Memo

Identify as per dwg & Stock Location:

Memo

0.00

0.00

250

Packaging Packaging

W/O:		WORK ORDER CHANGES										
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Tuesday, February 01, 2011 7:07:51 AM

Item ID:

D3391-023

Accept

Setup Start

Stop

**Revision ID:** 

Item Name:

Required Date: 2/1/2011

Mid Tube Assembly

**Start Date:** 

2/1/2011

QC:

Start Qty: 1.00

Operation

**Description** 

Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

**Process Plan:** 

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Reject

Qty

Sequence ID/

260

**Work Center ID** 

Memo

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Run

Accept

Qty

Start

Stop

Reject Insp. Number

Stamp

Quality Control

0.00

MF 02-02

W/O:			V	WORK ORDER CHAN	GES	<u></u>	<u></u> .			
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# ` Picklist Print

• Tuésday, February 01, 2011 7:07:48 AM

Work Order ID: 65983

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly



**Start Date: 2/1/2011** 

Required Date: 2/1/2011 Required Qty: 1.00

Start Qty: 1.00

IPP AU05.10.20 | New Issue KJ/ECI i IPP BI 106.02.10 | ECN773 dwg rev.D  $EC \sqcup$ 

07.03.20 rev F dwg IPP D 07.03.28 re-format

IPP E 07.10.31 ecn 1053P

EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

EC

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D2500-1-100  Skidtube Extrusion	I	Manufactured	No			100	Each	116.0000	1	1.	B	£ 11/02/01
e de la companya de l				Location		Loc	<u>Otv</u>	Loc Code				
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# **Picklist Print**

Tuesday, February 01, 2011 7:07:48 AM

Work Order ID: 65983

Parent Item:

D3391-023

Parent Item Name: Mid Tube Assembly



56802

57656

D3681-1

Spacer

Manufactured

160

Loc Qty

51

14

12

5

Each

20

Each

51.0000

Loc Code

Start Date: 2/1/2011

Start Qty: 1.00

11/02/06

Required Date: 2/1/2011

Required Qty: 1.00

D3591-1

Manufactured

No

63321 64620

**Location** 

LG

210

31.0000

Bushing

ALS4-1032-130

Purchased



Insert

<b>Location</b>	<u>Lo</u>	c Qty	Loc Code	
ST072		31		
47121		2		
57350		29		_
	230	Each	807.0000	20
			111	IIII 1881



20

X20

<u>Location</u>	Loc Qty
PKG11	480
114723	480
ST281	192
116049	192
ST282	96
110511	10
115911	86
ST381	39
114654	2//

Loc Code

1115079

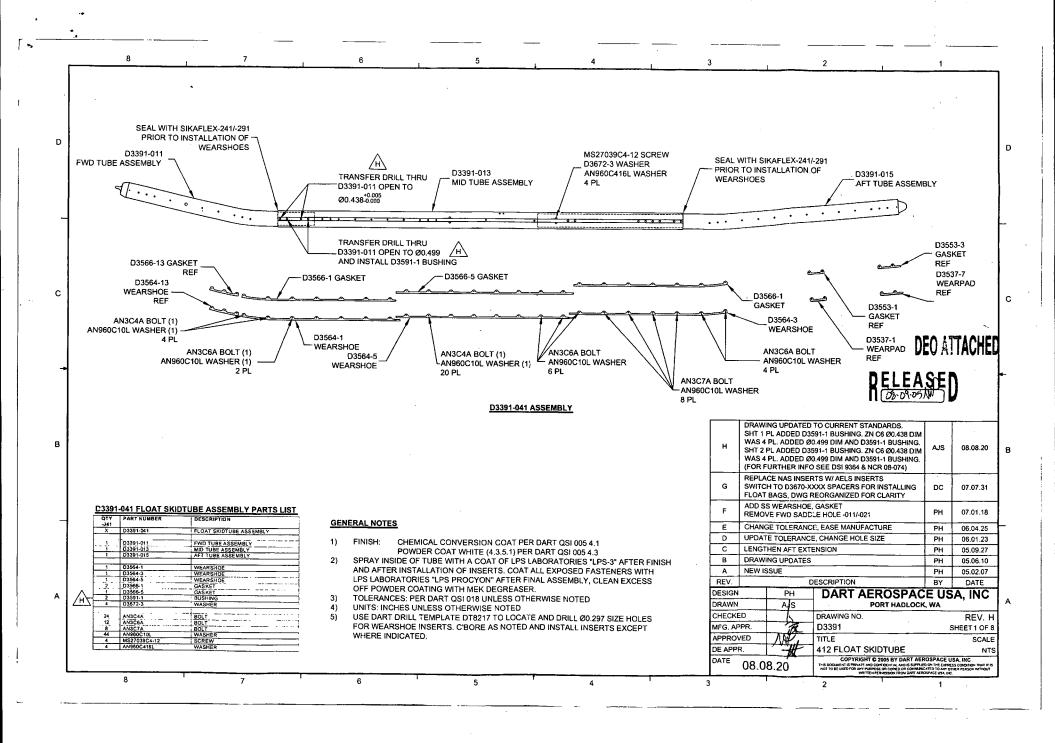
Tuesday, February 01, 2011 7:07:48 AM

Page 2

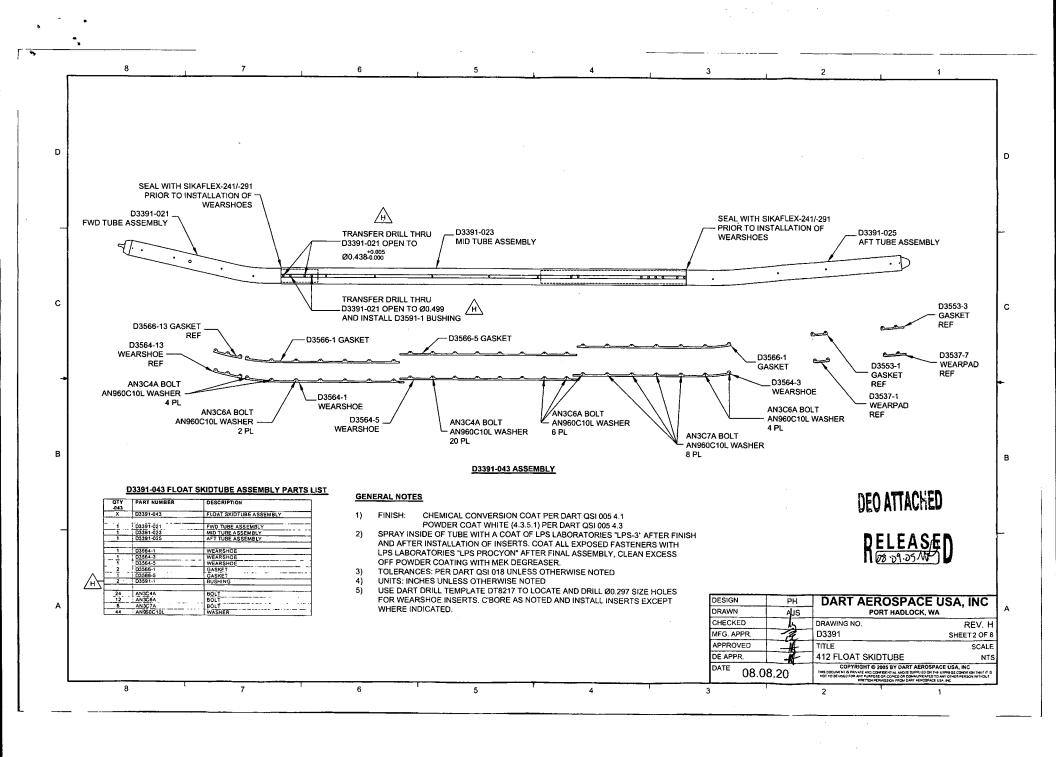
W/O: 65	5983	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE By Date				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: D339 1-023	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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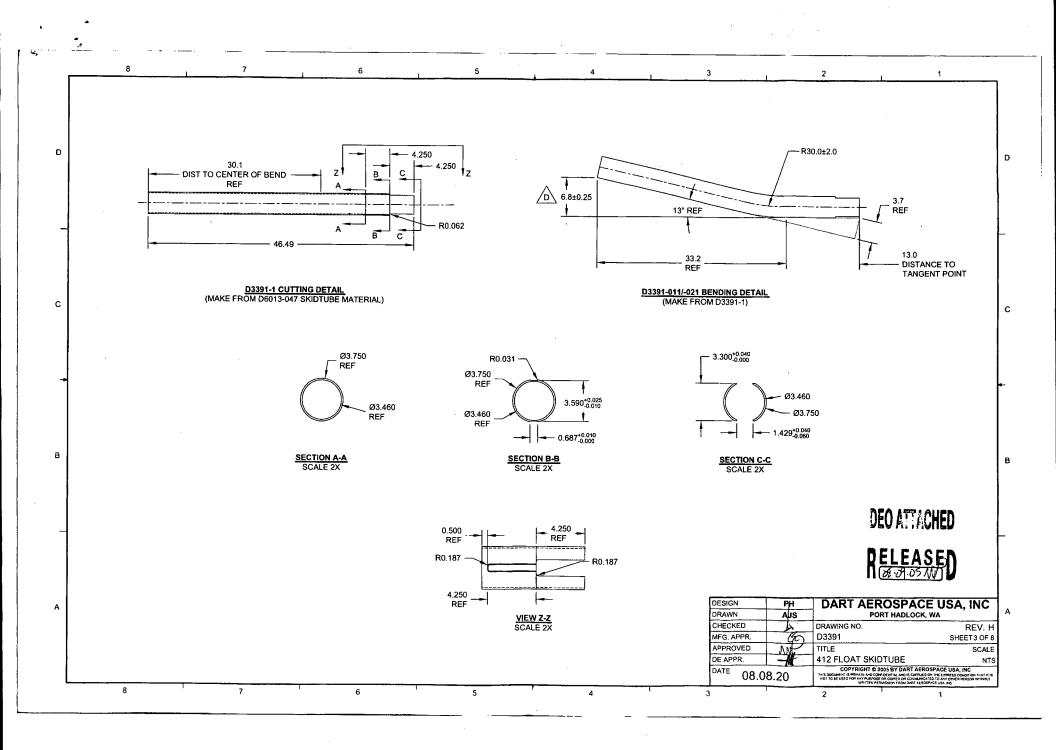


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NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	₹)			
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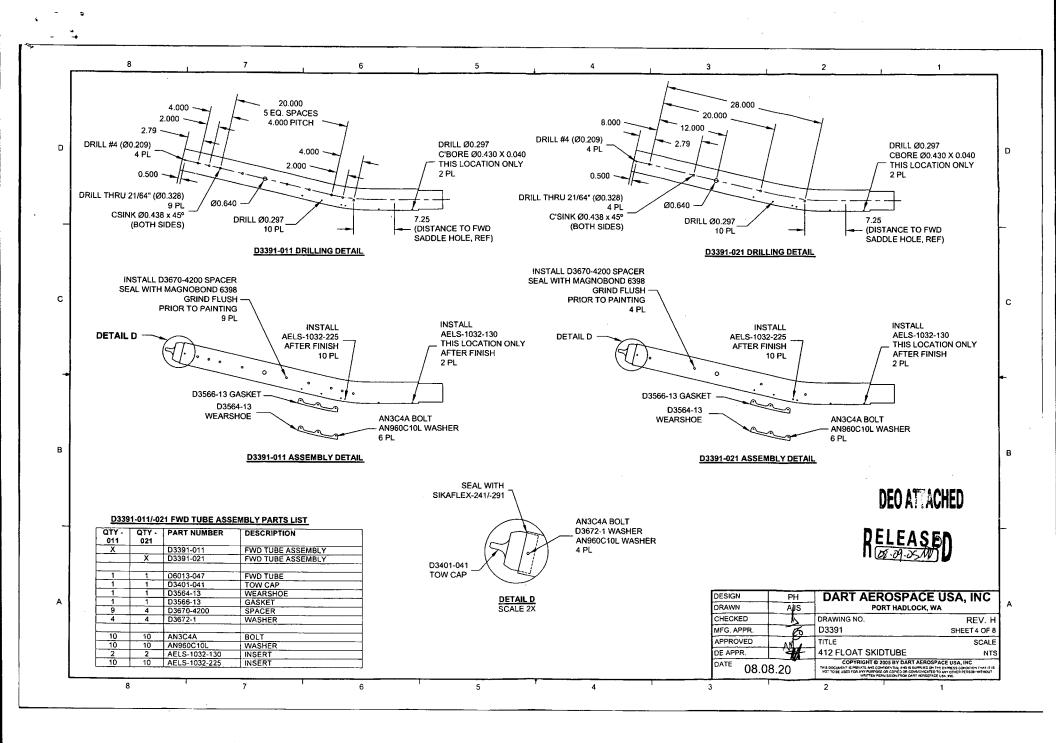


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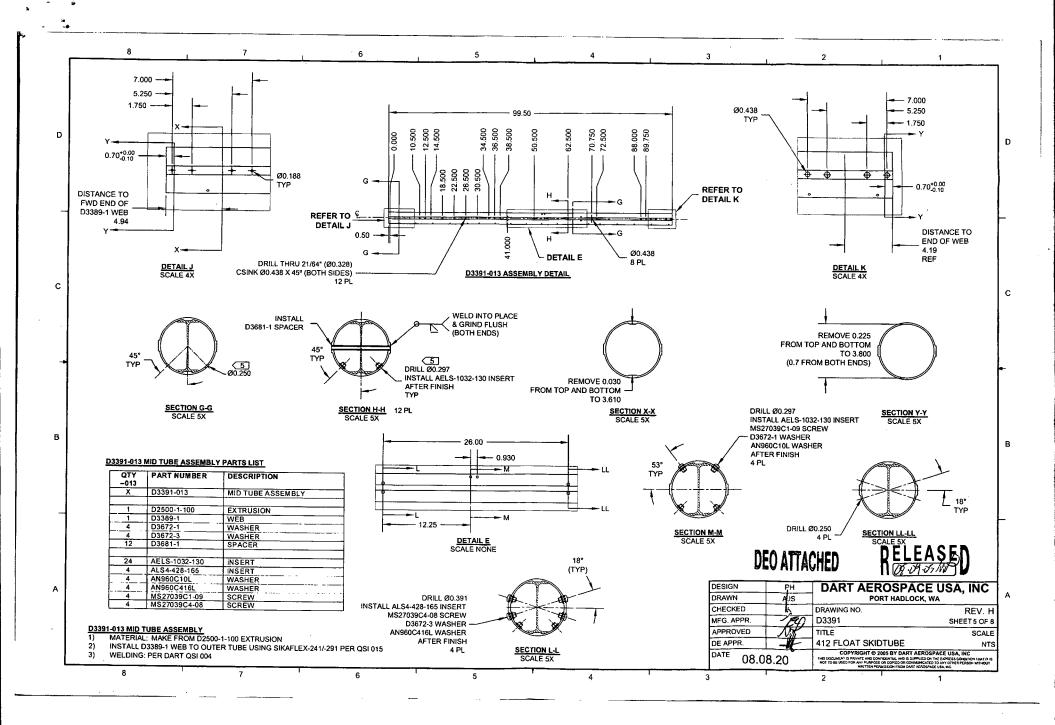
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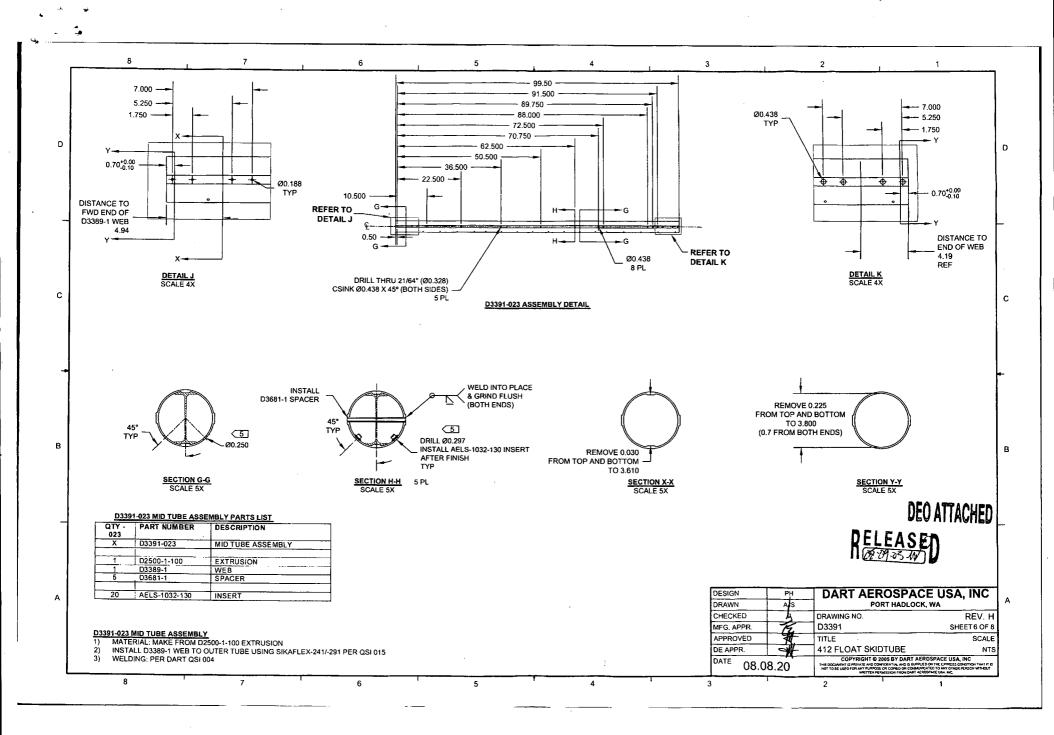


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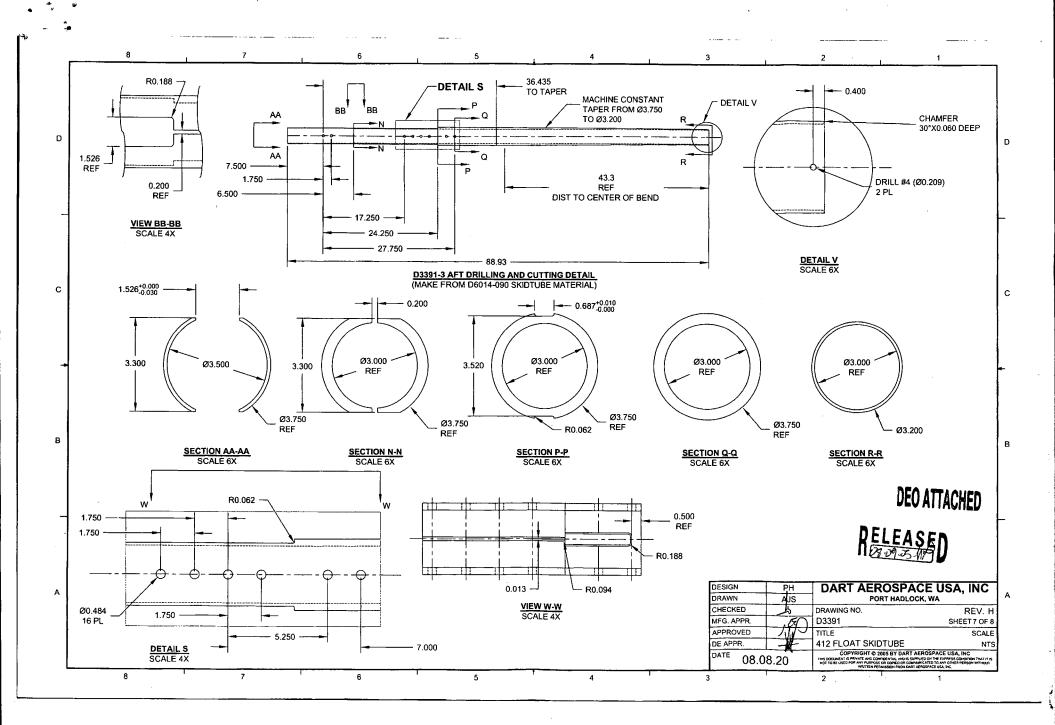
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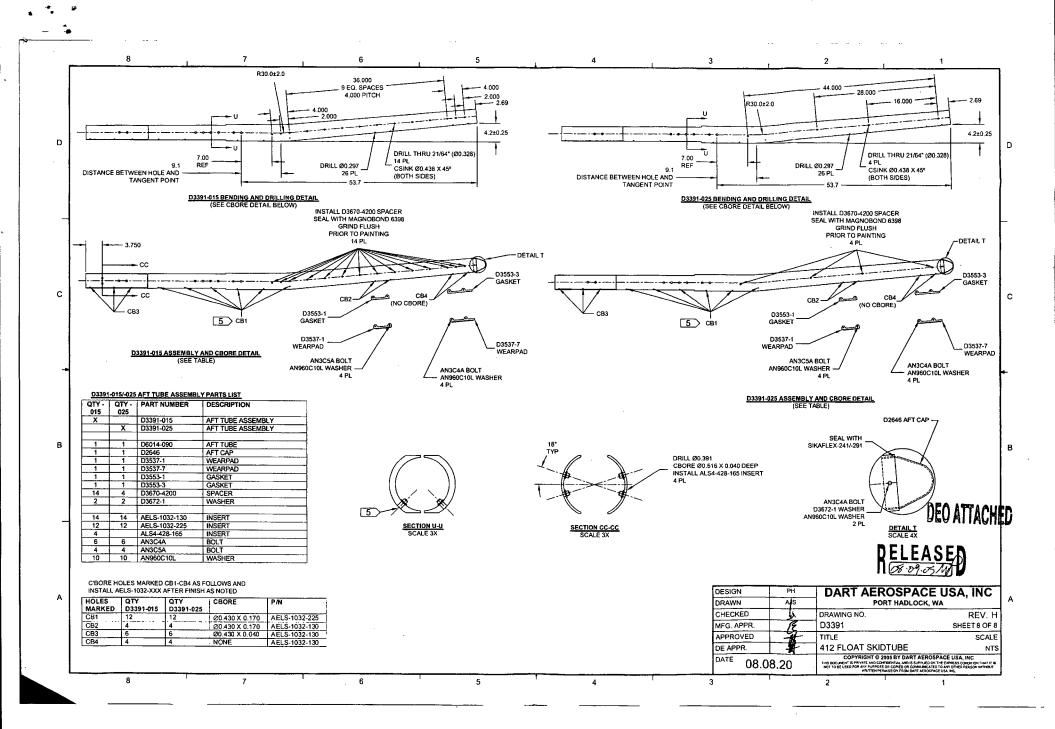


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#### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: Approval **Approval** DATE STEP By Chief Eng / PROCEDURE CHANGE Date Qty QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial QC Inspector Section A Section C Chief Eng Date Chief Eng Chief Eng



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DATE	STEP	Description of NC	Corrective Action		on B		cation	Approval	Approval
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PRAWING N	10.	TITLE		REV. H	DART AEROSPA	CE USA, INC D.E.O. NO.	SHEET NO.	SCALE
D3391		412 FLOAT	SKIDTUBE		ENGINEERING	<b>ORDER</b> D3391-H-1	SHEET 1 OF, 1	NTS
DRAWN	<u> </u>	<u> </u>	CHECKED	<u> </u>	MFG. APPR.	APPROVED MA	DE APPR.	
DATE	09.09.	23	DATE	04.04.24	DATE 09/09/	25 DATE 09/09/30	DATE 09/09/3	

#### **PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

#### CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A GOAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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		Description of NC		Corrective Action Section B	3	Verification	Approval	Approval
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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NO. <u>244</u>

# AWS D17.1.2001 QUALIFICATION TEST RECORD

2 11 th
Name: Darklay Ellia//
Job number: <u>65328</u>
Part number: <u>1339/ -023</u>
Description: mig tube
Welding Process: Tig[\(\beta\) Mig[]
Base materiel: <u>Cilliume Lea M</u>
Current: AC[ ] DC[ ]

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Lat hours  Welder Barkayy West	Date of Test Coupon // 0/-18  Date of Test Coupon // 0/-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld